

DART AEROSPACE LTD	Work Order:	24274
Description: Strut	Part Number:	D2565-103
04.04.06 05.05.06		
Drawing: D2565 Rev. 01, D2638 Rev. A	Qty:	20

Step	Location	Procedure	By	Date	Qty
1	EXPEDITING	Open W/O	FF	05.09.14	20
2	METAL	Punch 304/316/318-2B Seamless Tubing, 3/4" O.D. x 0.049" wall to length as per Dwg D2565 using DT 8313 Batch M10540 H10457	FF	05.10.30	20
3	METAL	Drill hole open to 3/250 as per Dwg D2565 (one end only) $\phi 0.316$ RF 04.12.07	DL	05/11/03	20
4	METAL	Deburr	DL	05/11/07	20
5	QC	Inspect Level 5	2	05.11.07	20
6	FINISHING	Powder Coat White (Ref 4.3.5.2) as per QSI 005 4.3	DL	05/11/21	20
7	QC	Inspect Level 3	CL	05/11/25	20
8	STORES	Bag and Tag LOC: 187	CL	05/11/25	20
9	EXPEDITING	Inspect Level 21 Close W/O Cost / Part 545 05/11/28 (20)	DL	05/11/28	20

Rev	Date	Change	Revised By	Approved
A	97.01.14	New Issue	KS	
B	98.10.29	Updated material, drawing revision	KS	
C	99.02.11	Added Inspection	DM	
D	99.06.16	Re-format	DM	
E	01.08.28	Added Powder coat, and added Inspection Levels 3 and 21.	SM	
F	02.04.16	Added dwg Rev. 01 D RF 02/04/24	NG	02.05.14

RELEASED

02/05/14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector





NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: LD Date: 05/11/28

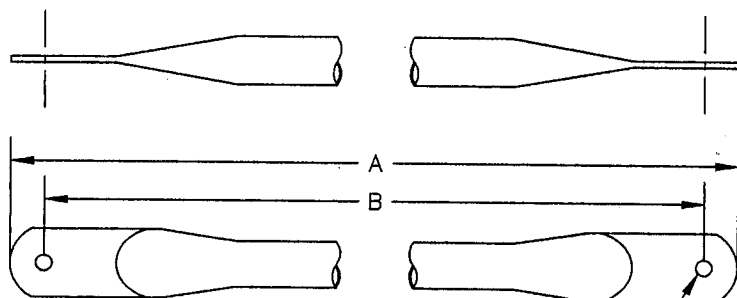
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



DESIGN 	DRAWN BY 	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D2565	REV. E SHEET 1 OF 1
DATE 04.05.05		TITLE STRUT	SCALE 1:3
A	96.05.03	NEW ISSUE	
B	97.03.15	CORRECT D2565-111 DIM. A	
C	98.10.05	UPDATED MATERIAL NOTE (TSR A603)	
D	02.06.05	ADD -3XX PARTS; ADD FINISH	
E	04.05.05	ADD D2565-401-411; RMV ANGLE D	

RELEASED
04.05.05



DIA 0.257 TO BE PUNCHED
"C" DIA TO BE OPENED MANUALLY

PUNCH ENDS PER SPEC CONTROL DRAWING D2638

PART #	A	B	DIA C
D2565-101	20.52	19.72	0.316
D2565-103	18.21	17.41	0.316
D2565-105	20.19	19.39	0.316
D2565-107	13.43	12.63	-
D2565-109	12.31	11.51	-
D2565-111	13.65	12.85	-
D2565-201	22.79	22.00	0.316
D2565-203	20.75	19.95	0.316
D2565-205	21.22	20.42	0.316
D2565-207	16.07	15.27	-
D2565-209	15.16	14.36	-
D2565-211	14.14	13.34	-
D2565-301	27.03	26.23	0.316
D2565-303	25.34	24.54	0.316
D2565-305	23.73	22.93	0.316
D2565-307	20.86	20.06	-
D2565-309	20.17	19.37	-
D2565-311	16.30	15.50	-
D2565-401	18.29	17.49	0.316
D2565-403	15.64	14.84	0.316
D2565-405	19.45	18.65	0.316
D2565-407	10.79	9.99	-
D2565-409	9.34	8.54	-
D2565-411	13.81	13.01	-

SHOP COPY

UNIT TO
DIMENSIONING

GENERAL NOTES

- 1) MATERIAL: AISI 304/316/318 SS 0.750 OD X 0.049 WALLU (REF DART SPEC. M304TR0.750W0.049) ENSURE SEAMLESS TUBE IS USED
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

IF COPY
SLIP
CUT NOTICE

WORK ORDER

NO. 24274

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RELEASED
75/07/05 KE

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Sep 13, 2005
03:34 pm

Work Order No : 0024274
Project Name : D2565-103
Project For : WK544
Work Order Type : Main
Main WO Number :
House Part Number : D2565-103
Description : Strut
Manufactured : Yes
Amount Req'd : 20
Amount Done : 0
Start Date : 09-13-05
Est Finish Date : 10-30-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Nov 08, 2005
11:14 am

Work Order No : 0024274
Project Name : D2565-103
Project For : WK544
Work Order Type : Main
Main WO Number :
House Part Number : D2565-103
Description : Strut
Manufactured : Yes
Amount Req'd : 20
Amount Done : 0
Start Date : 09-13-05
Est Finish Date : 10-30-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	1.55	100.00		
Production Cost :	0.00	23.95	100.00	0.00	23.95
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	23.95	100.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	23.95			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	(-23.95)

Mis 01B
u
11.13

Date: Monday, 14/11/2005 8:40:54 AM
User: Alba Panzulo













Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	STRUT
Job Number :	24274		
Estimate Number :	10275		
P.O. Number :		Part Number :	D2565103
This Issue :	14/11/2005	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D2565 REV E
First Issue :	//	Project Number :	
Previous Run :		Drawing Revision :	E
	Type :	Material :	
	SMALL /MED FAB	Due Date :	30/11/2005
Written By :		Qty:	20
Checked & Approved By :		Um:	Each
Comment :	Est: F02.04.16 Added dwg Rev.C1 NG		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304TR0750W049	304 RD Tube .750 x .049W
2.0	BRAKE NC	NC BRAKE
		
Comment: BRAKE NC Punch to length as per Dwg D2565 using DT8313		
3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
		
Comment: SMALL & MEDIUM FAB RESOURCE 1 1-Drill hole open to .3125 Ø as per Dwg D2565 (one end only) 2-Deburr		
4.0	QC5	INSPECT WORK TO CURRENT STEP
		
Comment: INSPECT WORK TO CURRENT STEP		
5.0	POWDER COATING	POWDER COATING
		
Comment: POWDER COATING Powder Coat White (Ref: 4.3.5.2) as per QSI 005 4.3		
6.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
		
Comment: INSPECT POWDER COAT		
7.0	PACKAGING 1	PACKAGING RESOURCE #1
		
Comment: PACKAGING RESOURCE #1 Identify and Stock Location:_____		

Date: Monday, 14/11/2005 8:40:54 AM
User: Alba Panzuto

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT

Job Number: 24274

Part Number: D2565103

Job Number:



Seq. #:

Machine Or Operation:

Description :

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



